

What is claimed is:

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1. A reusable, collapsible, cleanable shipping container having:
a bottom with a peripheral edge,
first and second opposed pairs of walls,
hinges connecting the walls each to an edge of the bottom, the hinges being
informed of a unitary piece of resilient, flexible material fused to the walls and
bottom to form a seamless joint[?] their between,
the walls having a first open position in which they extend away from the bottom
and lie generally in the plane of the bottom, and
a second, erect position in which the walls extend upward from the base to form
a container, and
force transmitting surfaces on the walls and bottom that transmit forces between
the walls and the bottom when the walls are in the erect position and thereby limit
the extent to which said forces are transmitted between the walls and bottom
through the hinges.
 2. The container of claim 1 wherein the bottom includes elevated surfaces for
mounting at least some of the hinges.
 3. The container of claim 2 wherein alternate walls are hinged to elevated
surfaces.
 4. The container of claim 1 where in the walls each define a plane and the
surfaces on the walls include surfaces substantially normal to the respective
planes.

TOP SECRET

5. The container of claim 4 wherein the bottom includes a T shaped projection that forms a part of the force transmitting surfaces.
6. The container of claim 4 wherein the bottom includes at least two T shaped projections and at least some of the walls include T shaped openings that cooperate with the T shaped projections of the bottom to transmit loads between the walls and the bottom.
7. The container of claim 1 wherein the walls define an outside surface when in the erect position and include a recess for receiving a band extending around the outside surface that retains the walls in the erect position.
8. The container of claim 7 wherein the band is removable.
9. The container of claim 7 wherein the walls include a ribs and the recess includes notches formed in the ribs adjacent an edge of at least some of the walls.
10. The container of claim 3 wherein the walls have a third position in which alternate walls are folded flat against the bottom, and the remaining walls are folded against the alternate walls.
11. The container of claim 1 wherein the walls and bottom are formed of a thermoplastic material and the hinges are formed of a different thermoplastic material.
12. The container of claim 11 wherein the walls and bottom are injection molded and thereafter the hinges are injection molded, the process of injection molding the hinges simultaneously fusing the hinges to the walls and bottom.
13. The container of claim 1 including a third opposed pair of walls.